

5/43

DART AEROSPACE LTD	Work Order:	24609
Description: Lug Assembly	Part Number:	D3414-041
Dwg: D3414 Rev. A	Qty:	20
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	05.10.18	20
2	PG	Issue P/O: <u>2008855</u> Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3414-1F Possible Supplier: Industrial Laser Material release note is required	AP	05-19-24	20
3	RG	Receive and Inspect for transit damage Enure material release note is attached	10	05/11/22	21
4	QC6	Inspect dimensions as per template D2658T1 & Dwg D3414	2	05-12-13	21
5	GA	Deburr	SAD	05/12/18	21
6	GB	Form using DT8254 as per Dwg D3414	SB	05/12/21	21
7	QC5	Inspect work to Step 6	2	05-12-21	21
8	WS	Weld using location Jig DT8484 as per Dwg D3414 Pick: Qty Part Number Description Batch 1 D3414-3 Lug 324224 324610 A/R SS Rod M13066	CPL	05-12-23	21
9	QC9/5	Inspect weld and work to Step 8	PD	06-01-03	21
10	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	M	06-01-03	21
11	QC3	Inspect Powder Coat	CL	06/01/04	21
12	ST	Identify and Stock LOC: 70	CH	06/01/04	21
13	AC	Cost / part: _____	SUE	06/01/05	21
14	DC	Close W/O Inspect Level 21	SP	06/01/05	21

Rev	Date	Change	Revised By	Approved
A	05.09.13	New issue	KJ/JLM	

RELEASED
05-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05/10/24	2	permanent change		05-10-24 05-01-05		U	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/01/05

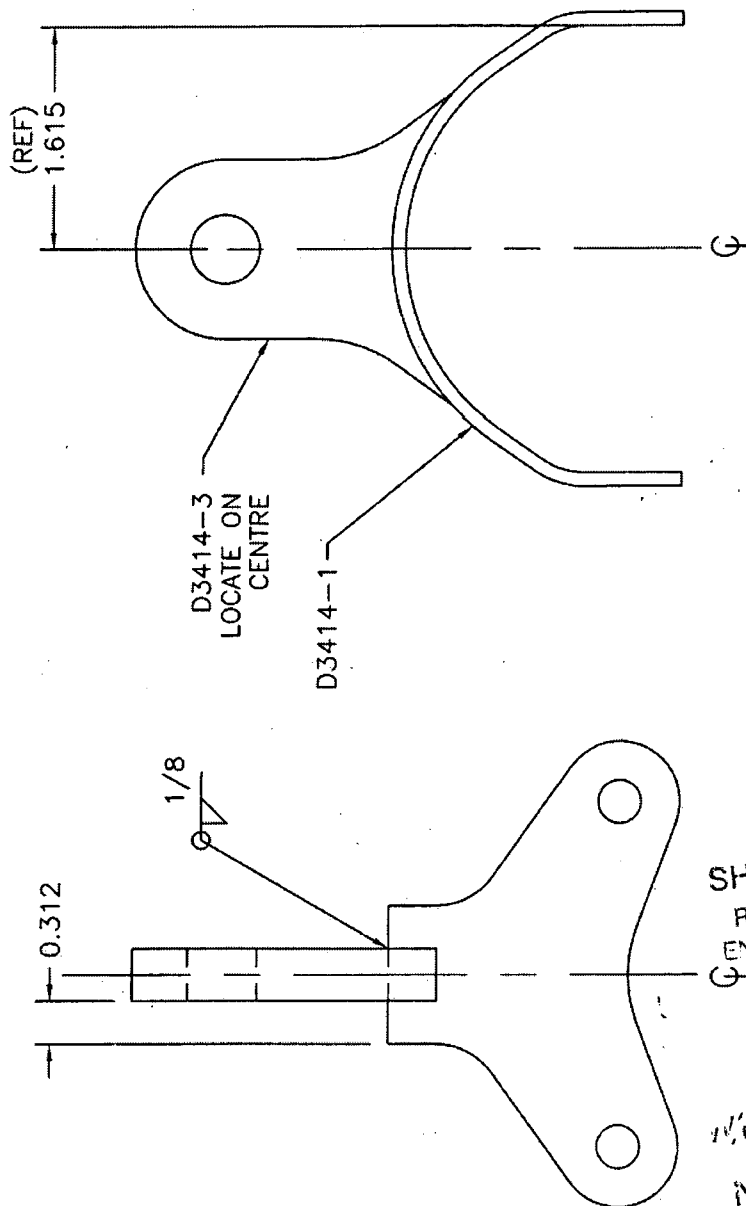
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	
		PORT HADLOCK, WA			
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. A
				D3414	SHEET 1 OF 3
DATE				TITLE	SCALE
05.03.16				LUG ASSEMBLY	NTS
A	05.03.16			NEW ISSUE	

RELEASED
05.09.06 *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING

CONTROLLED COPY

ENDMENT
NOTICE

ORDER

NO. 24609

D3414-041 LUG ASSEMBLY

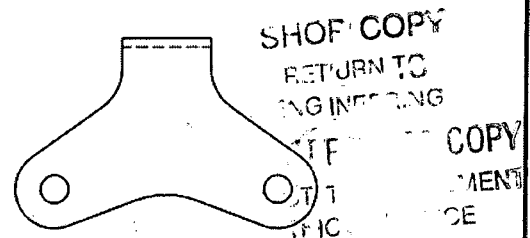
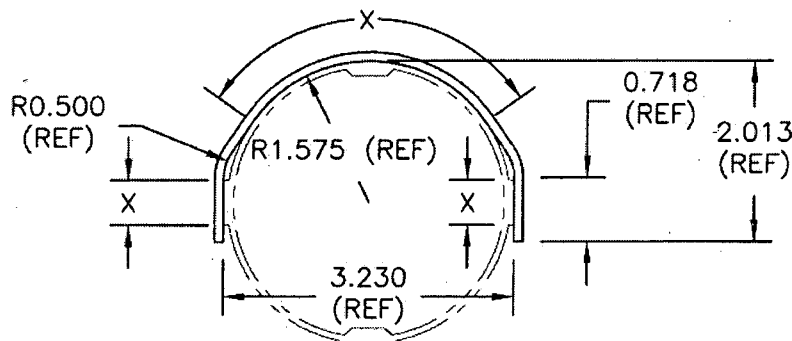
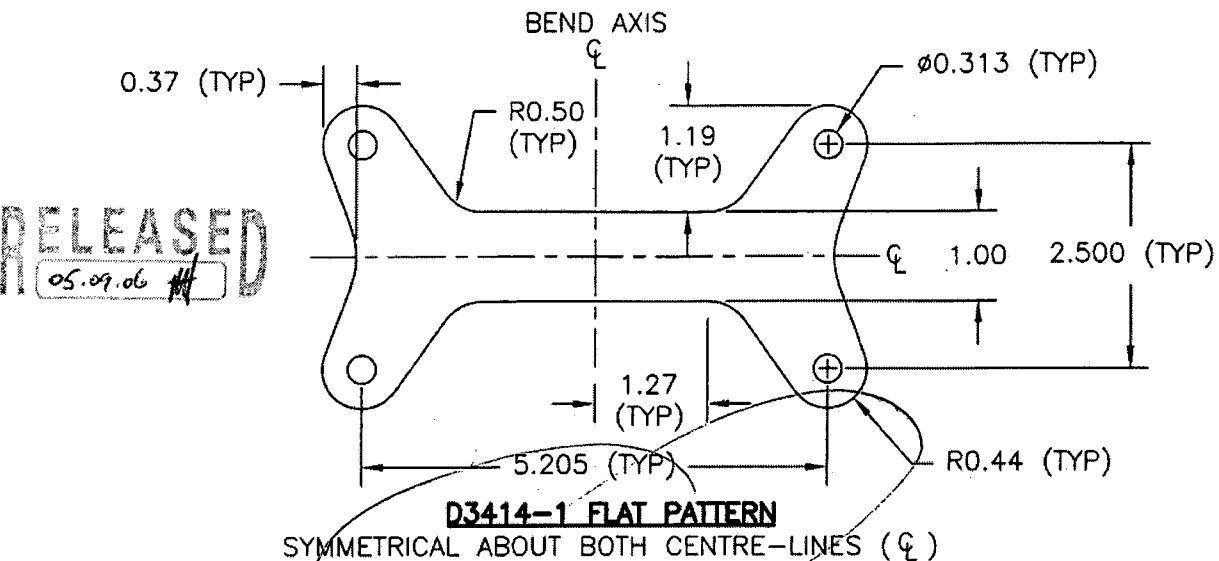
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE

Copyright © 2005 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 2 OF 3
DATE 05.03.16	TITLE LUG ASSEMBLY		SCALE 1:2

RELEASED
05.09.06 *[Signature]*WORK ORDER
NO. 24609**D3414-1 BEND DETAIL**

D3414-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3414-1 LUG BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 0.100 THICK (12 GAUGE, REF DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

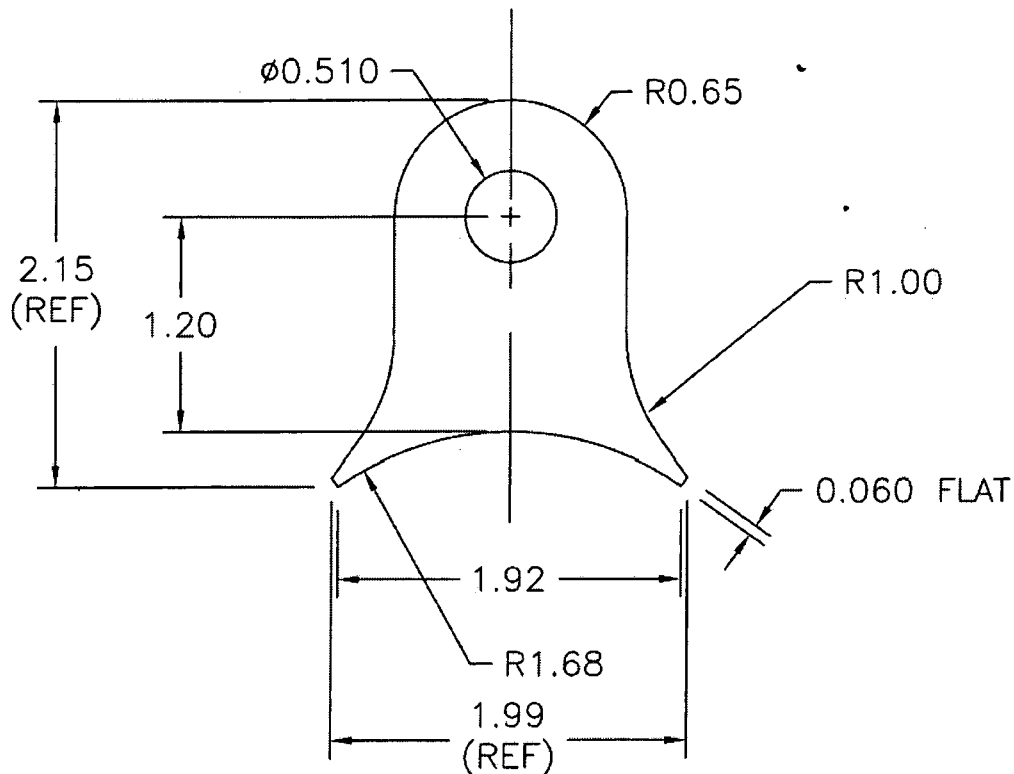
Copyright © 2005 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 3 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE 1:1

RELEASED
05-09-06 *[Signature]*

**D3414-3 LUG**

- 1) MATERIAL: AISI 304/316 SS PLATE 0.375 THICK (REF DART SPEC. M304S)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING

DATE COPY
24609
DEP

Copyright © 2005 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 18, 2005
03:21 pm

Work Order No : 0024609
Project Name : D3414-041
Project For : WK543
Work Order Type : Main
Main WO Number :
House Part Number : D3414-041
Description : Lug Assembly
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 10-18-05
Est Finish Date : 10-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Certificate: 195536 01 Mail To:
ALASKAN COPPER & BRASS CANADA, INC.
P.O. BOX 3546
SEATTLE, WA 98124-3546

Ship To:
ALASKAN COPPER & BRASS CANADA, INC.
225 NORTH ROAD AVENUE
COQUITLAM, BC V3K3V7
CANADA

Date: 8/25/2003 Page: 1

Steel: 304

Finish: 2B

Your Order: 45002847

NAS Order: AE 0262451 03

Corrosion: ASTM A262/01M, 190 Bend-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/02, A480/02, A666/00, ASME SA240/01, SA480/01, SA666/01
Q8766D-A X MG PRM, AMS5513G X MRK&FIN, MIL5059D, AND3, X CRWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces
B00675	* 0620K1 E	.1050	48.0000	5,085	96.0000	SHEET	1
B00676	* 0620K1 E	.1050	48.0000	1,060	96.0000	SHEET	2

CHEMICAL ANALYSIS

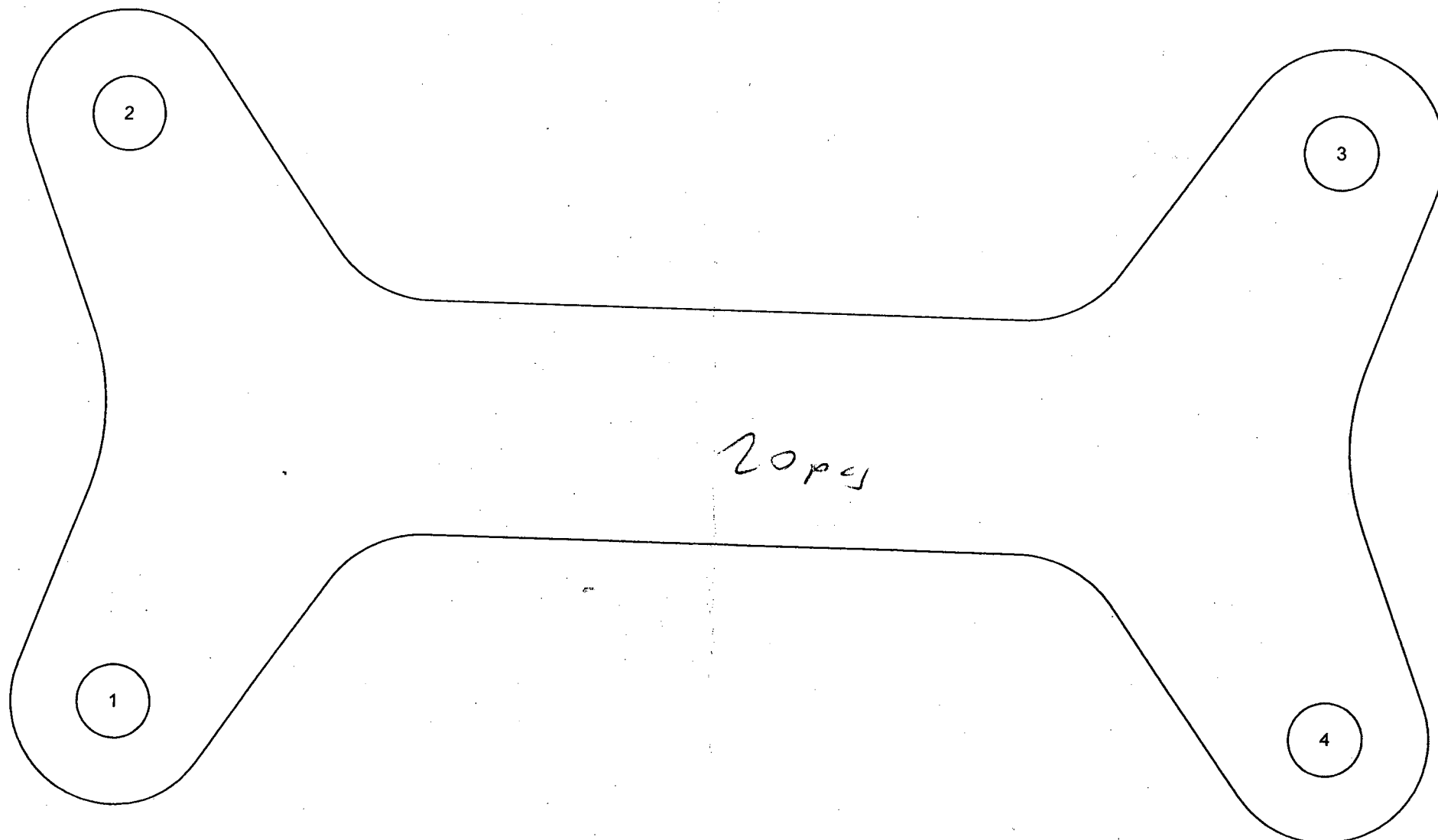
Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
20K1	.057	18.344	.425	1.742	.410	.057	8.167	.031	.001	.335

MECHANICAL PROPERTIES

Product ID #	Coil #	Id oi cr	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail H Tail
B00675	0620K1	F T	96.48	50.89	45.97	88.50	87.50
B00676	0620K1	F T	96.48	50.89	45.97	88.50	87.50

Drawing name..... D3414 REV.A
Revision.....
Material number..... 0031, STAINLESS 12GA, .105
Last modified date... 11-14-2005
Prgrammed by..... jm

Comment.....
Customer name... dart
Description.....
Specification.....



Cutting distance = 24.4897
Rapid distance = 14.3036